

Work Order ID 68690

Wednesday, April 20, 2011 8:22:18 AM



Page 1

Item ID: D350-591-214

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short RH

Start Date: 4/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *H*Date: *1204-20* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3078	A
DSI 9472	A

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

*8 u 10/19**Star BG 11-7-15*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

*MAE 11-06-10**(X4)**0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									
130	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078 A/RAluminum Rod 114703 117884 2-Grind End Plate flush								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

11-06-03

11-06-00 4 0
11-07-05 4 0

4 0 11-07-05

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 05 (4)

160

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11.07.07.

4 0

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SB 11/07/14

(4)

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Rivet Leg Assembly as per Dwg D3078.

2- Bevel Aft end for welding

3- Inspect for foreign object as per QSI 024

4- Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod ~~114703~~

5- Grind End Plate flush

*Mc/Ae 11.07.12.**Mc 11.07.13*

4

Ø

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

*8 11.07.14**(24)
RH*

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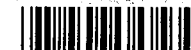


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Revision ID:

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Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

QC5- Inspect part completeness to step on W/O

0.00



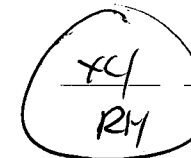
QC

Memo

0.00

Quality Control

5/11/07/14



230

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4RM H 11/07/14

240

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M117745

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:25
320°
9:55

4 RH BL 11-7-18

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Required Date: 4/25/2011 Req'd Qty: 4.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 117863 Memo	0.00 0.00				4 RH		11/10/11	
260  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				x4 RH			
270  Packaging Packaging	Pick Kit Memo	0.00 0.00						11/7/15	

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Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
290	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-214								
	Location: <u>30</u>								
	PPP Rev: <u>5</u>								
300	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

8/26/19

44
R12

11/7/19

42

11/7/19

mf
11-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 1

Work Order ID: 68690

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D
 10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

110

Each

145.0000

0.5

2



Step Extrusion



A.E 11.06.10

Location

Loc Qty

Loc Code

HALL

16

64409

16

WA

129

46910

2

64409

1

66970

126

D3063-1

Manufactured

No

130

Each

34.0000

1



Support



4

11.06.20

Location

Loc Qty

Loc Code

WA

20

66182

20

WA016

14

59663

14

D3067-1

Manufactured

No

130

Each

65.0000

1



End Plate



4

11.06.20

Location

Loc Qty

Loc Code

WA

60

67582

60

WA016

5

65969

5

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

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Parent Item Name: Heli-Access-Step, Short RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

D3066-1
Spacer
Manufactured No

200 Each 42.0000 2 8

 Ac 11.07.12

Location	Loc Qty	Loc Code
WA015	42	
66131	2	
67581	40	

MS20600-AD4W4
Rivets
Purchased No

200 Each 2,088.000 16 64


 Ac 11.07.12

Location	Loc Qty	Loc Code
ST321	2083	
116188	1083	
117364	1000	
WA018	5	
116712	5	

B 117885 (X64)

D3065-041
Step Leg Assembly Hi
Manufactured No

200 Each 15.0000 1 4


 Ac 11.07.12

Location	Loc Qty	Loc Code
WA014	15	
66149	1	
66808	14	

B69740 (X4)

D3067-1
End Plate
Manufactured No

200 Each 65.0000 1 4

 Ac 11.07.13

Location	Loc Qty	Loc Code
WA <u>B70700</u>	60	
67582	60	
WA016	5	
65969	5	

4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 68690

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Parent Item Name: Heli-Access-Step, Short RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-16A
Bolt

Purchased No

270 Each

88.0000 4

16

M117514

Bolt

Location

Loc Qty

Loc Code

ST358

88

116400

88

D2732
Rubber Extrusion

Manufactured No

270 f

323.5000 1

4

Location

Loc Qty

Loc Code

ST410

323.5

64283

323.5

Cut 3.00" long, qty 4

AN3-35A
Bolt

Purchased No

270 Each

141.0000 2

18 5x

3x

M117619

M117714

Bolt

Location

Loc Qty

Loc Code

ST353

141

117313

91

117441

50

AN4-11A
Bolt

Purchased No

270 Each

230.0000 2

18

Location

Loc Qty

Loc Code

ST357

230

110382

30

115316

200

AN960JD416

NAS1149D0463J

Purchased No

270 Each

0.0000 12

48

Washer

M117591 11/7/15

Wednesday, April 20, 2011 8:22:28 AM

Shop Packet Print

Page 3

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Parent Item Name: Heli-Access-Step, Short RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

D2230-3

Manufactured No

270 Each

43.0000

2

8



Lug



B706942

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST476

39

67827

39

D2856-400

Manufactured No

270

f

216.6696

0.6



Abraison Strip



2.4

Location

Loc Qty

Loc Code

ST403

216

68076

216

ST409

0.6696

63735

0.6696

2.4

cut.7.20" long, qty 1

MS21042L3

Purchased No

270

Each

2,500.000

2



Nut



1.8
11/7/15

Location

Loc Qty

Loc Code

ST300

2500

116391

126

116540

800

116549

774

117441

800

2

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Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-13A Purchased No 270 Each 356.0000 4 16
 *M117962*

Bolt

Location	Loc Qty	Loc Code
ST357	356	
117313	356	

D2230-1 Manufactured No 270 Each 155.0000 2 8
 *38179*

Lug

Location	Loc Qty	Loc Code
ST476	155	
65270	2	
67396	53	
67761	100	

MS21042L4 Purchased No 270 Each 5,442.000 6 24
 *sp*

Nut

Location	Loc Qty	Loc Code
ST300	5442	
116188	442	
116823	2000	
117441	3000	

AN960JD10 NAS1149D0363J Purchased No 270 Each 0.0000 4 16
 *M117291 11/15/11*

Washer

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68690

11-04-20

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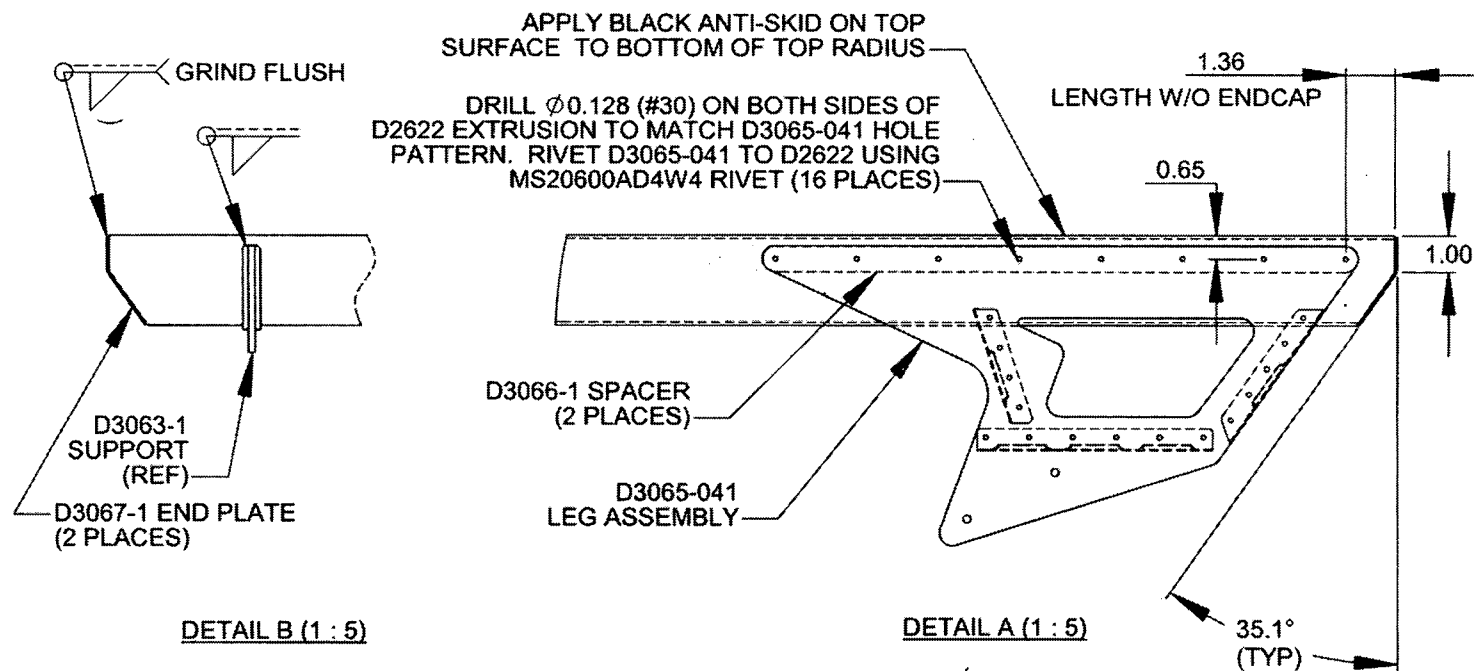
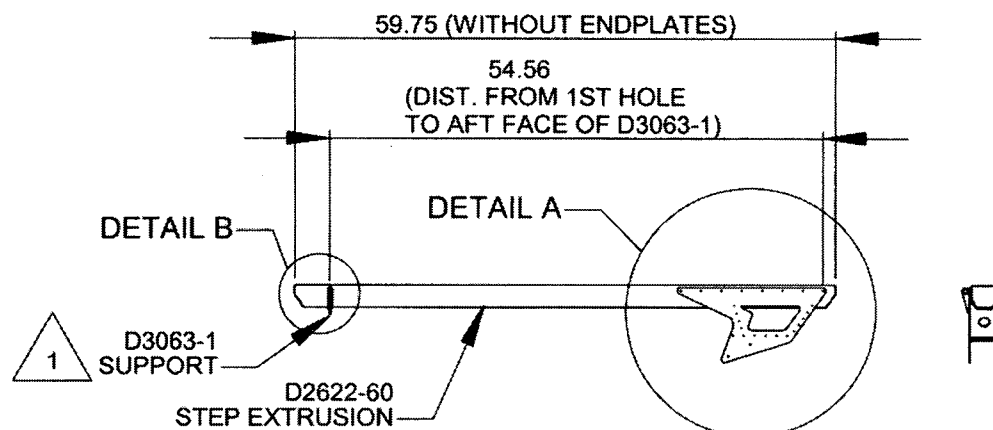
NOTE: Date & initial all entries

DART



RELEASED
02.09.2004

DESIGN	W	DRAWN BY	W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	W	APPROVED	W	DRAWING NO. D3078
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	



DETAIL B (1:5)

DETAIL A (1:5)

u106869d

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

u/b 68690

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED 
BY: <u>D. SHEPHERD (DE # 02)</u>
DATE: <u>09.08.05</u>
CERT. NO.: <u>SH92-6</u>
ISSUE NO.: <u>11</u>

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>92</u>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>UP</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>N/A</u>	DSI 9472	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

WLO 48698

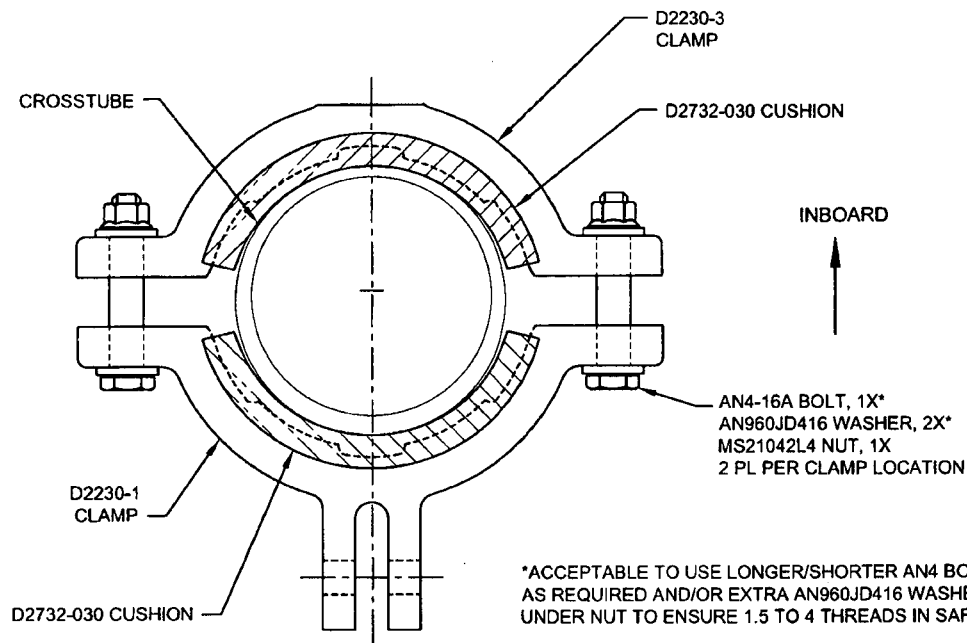


FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
APPROVED	WJ	TITLE	SCALE
DE APPR.	TH	BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4			AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G
Date: 08.10.06

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

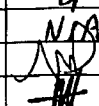

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. REV. A	
CHECKED	4	DSI 9472 SHEET 1 OF 2	
MFG. APPR.	N/A	TITLE SCALE	
APPROVED		BOLT ADDITION NTS	
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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